



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2521
Job Sheet 202741



Part No: D2521

Job Qty: 24 pcs

Part Name: Individual Bearpaw



Part Weight: 0 lbs

Job Created: 11/1/19

Due Date: 11/29/19

Type: Stock

Status: New

Priority: Medium

Job Tracking No:

Created By: Linda Lacelle

Description:

Note: DWG REV J IPP Rev:A 08-10-01 New Manufacturing Method JLM Verified By:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Purchasing	24 pcs	11/29/19	11/29/19	0.00	0.00	Purchasing - 1		11/29/19 NOV 11 2019
							Purchasing - 2		
							Purchasing - 3		
100	Packaging 2-1 - Receive - B4B	24 pcs	11/29/19	11/29/19	0.00	0.00	Packaging 2 - 1 - B4B		11/29/19 NOV 11 2019
							Packaging 2 - 2 - B4B		
							Packaging 2 - 3 - B4B		
							Packaging 2 - 5 - B4B		
							Packaging 2 - 4 - B4B		
							Packaging 2 - 6 - B4B		
							Packaging 2 - 7 - B4B		
							Packaging 2 - 8 - B4B		
							Packaging 2 - 9 - B4B		
							Packaging 2 - 10 - B4B		
							Packaging 2 - 11 - B4B		
							Packaging 2 - 12 - B4B		
							Packaging 2 - 13 - B4B		
							Packaging 2 - 14 - B4B		
							Packaging 2 - 15 - B4B		
							Packaging 2 - 16 - B4B		
							Packaging 2 - 17 - B4B		
							Packaging 2 - 18 - B4B		
							Packaging 2 - 19 - B4B		
							Packaging 2 - 20 -		

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1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S230590



Part: D2521

Job No: 202741

Serial No/Batch: S230590

Revision: J

Inspector:

Exp Date:

Instructions: Various STC's

Date: 11/1/19

				B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
110 QC 6	24 pcs	11/29/19	0.00 0.00	QC 6 - 9	
				QC 6 - 68	DAS
				QC 6 - 61	81
				QC 6 - 40	9-89
				QC 6 - 81	NOV 12 2019
130 HAAS 4 Axis - B4B	24 pcs	11/29/19	1.00 41.67	HAAS - 1 - B4B	DTP 11-11-21
				HAAS - 2 - B4B	
				HAAS - 3 - B4B	
				HAAS - 4 - B4B	
140 QC 2	24 pcs	11/29/19	0.00 0.00	QC 2 - 1	
				QC 2 - 12	
				QC 2 - 14	
				QC 2 - 17	
				QC 2 - 19	
				QC 2 - 2	
				QC 2 - 20	
				QC 2 - 22	
				QC 2 - 23	
				QC 2 - 25	
				QC 2 - 32	
				QC 2 - 33	
				QC 2 - 35	
				QC 2 - 39	
				QC 2 - 4	
				QC 2 - 40	
				QC 2 - 44	
				QC 2 - 45	
				QC 2 - 48	
				QC 2 - 49	
				Plex 11/1/19 10:59 AM dart.lacelle.linda	

				QC 2 - 50	
				QC 2 - 51	
				QC 2 - 52	DAS
				QC 2 - 57	52 19/11/20
				QC 2 - 62	9-89
				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	DAS
				QC 2 - 73	73
				QC 2 - 69	9-89
150 QC 8	24 pcs	11/29/19	0.00 0.00	QC 8 - 12	
				QC 8 - 14	19/11/25
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
160 Packaging 3-1 - Stock - B4B	24 pcs	11/29/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	

					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	PC ST 479A
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
170	QC 21 - SA	24 pcs	11/29/19	0.00 0.00	QC 21 - SA - 21	DAS
					QC 21 - SA - 70	21
					QC 21 - SA - 53	NOV 27 2019

Part Op 90 - 1-Issue PO: 44781 2-Cut blanks as per D2521_BLANK file.
Descriptions: 100 - Receive & Inspect for Damage & Mat'l Certs.
110 - QC6- All purchased or subcontracted products
130 - (HAAS CNC vertical machine #1) 1-Inspect material for defects or damage prior to machining 2-Machine as per Folio and Dwg D2521 Identify as D2521
140 - (QC2- Inspect parts off machine FAI/FAIB)
150 - (QC8- Inspect parts - second check)
160 - (Identify as per dwg & Stock Location:)
170 - (QC21- Final Inspection - Work Order Release)

Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
D2521P	Individual Bearpaw	142 Ea (1 ea)	90-Purchasing	S-230584	
MUHMWB10	UHMW 1" Black - 48"x120" Tivar Mfg.#52480104	168 sf (7 ea)	90-Purchasing		

9 pcs used S154152
= 63 sf

5 pcs used S22871
= 35 sf

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Purchasing	D2521P	24	0	0
	MUHMWB10	168	666	0
Part Specifications				
Specifications could not be found.				

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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044981



Supplier: ACI002-VC
Acier Duval Steel
5888 Country Road 17
Plantagenet
ON
K0B 1L0 Canada
Phone: 613-673-5474
Fax: 613-673-4576

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044981
PO Date: 11/1/19
Due Date: 11/15/19
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground
Pymt Terms: Net 30
Freight Terms: Prepaid
Special Comments:

Items

Line Item	Job	Part	Drawing	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	202736	D2432P	D2432 Rev H			Bearpaw 19" X 24" - cut blanks as per D2432_NEST7 file	Firmed X74	-	11/15/19	24 Ea	0 Ea	24 Ea	\$35.26/Ea	\$846.24
													NOV 1 1 2019	
2	202735	D2432P	D2432 Rev H			Bearpaw 19" X 24" - cut blanks as per D2432_NEST7 file	Firmed X24	-	11/18/19	24 Ea	0 Ea	24 Ea	\$35.26/Ea	\$846.24
													NOV 1 1 2019	
3	202734	D4355-1P	D4355 Rev B			Bearpaw - cut blanks as per D4355-1 file	Firmed X6	-	11/15/19	6 Ea	0 Ea	6 Ea	\$44.88/Ea	\$269.28
													NOV 1 1 2019	
4	202733	D4930-3P	D4930 Rev B			Bearpaw - cut blanks as per D4930-3 file	Firmed X8	-	11/15/19	8 Ea	0 Ea	8 Ea	\$25.61/Ea	\$204.88
													NOV 1 1 2019	
5	202732	D4930-1P	D4930 Rev B			Bearpaw - cut blanks as per D4930-1 file	Firmed X4	-	11/15/19	4 Ea	0 Ea	4 Ea	\$23.09/Ea	\$92.36
													NOV 1 1 2019	
6	202731	D5377-1P	D5377 Rev A			Bearpaw - cut blanks as per D5377-1 file	Firmed X8	-	11/15/19	8 Ea	0 Ea	8 Ea	\$48.89/Ea	\$391.12
													NOV 1 1 2019	
7	202742	D4353-041P	D4353 Rev B			Bearpaw - cut blanks as per D4353-041 file	Firmed X13	-	11/15/19	10 Ea	0 Ea	10 Ea	\$42.68/Ea	\$426.80
													NOV 1 1 2019	

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PURCHASE ORDER



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER
POHB044981



Items

Line Item	Job	Part	Drawing	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
8	202741	D2521P	D2521 Rev A			Individual Bearpaw - cut blanks as per D2521_BLANK file	Firmed X14	-	11/15/19	14 Ea	0 Ea	14 Ea	\$57.77/Ea	\$808.78
										DAS 81 9-89	NOV 11 2019			
9	202740	D4297-1P	D4297 Rev C			Bearpaw - cut blank as per D4297-1 file	Firmed X16	-	11/15/19	6 Ea	0 Ea	6 Ea	\$33.18/Ea	\$199.08
											NOV 11 2019			
10	202737	D2435P	D2435 Rev E1			Bearpaw - cut blank as per D2435 file	Firmed X12	-	11/15/19	12 Ea	0 Ea	12 Ea	\$26.45/Ea	\$317.40
												NOV 11 2019		
Grand Total:														\$4,402.18

Order Notes

Procurement Quality Clauses
A005 RIGHT OF ENTRY
A016 PERSONNEL QUALIFICATION
A026 CERTIFICATION OF MATERIAL CONFORMANCE
A032 DOCUMENT SPECIAL REQUIREMENTS
A033 STATEMENT OF CONFORMITY/TEST RECORDS FOR NAS, AN and MS FASTENERS
A040 NOTIFICATION OF QUALITY ESCAPE
A041 QUALITY MANAGEMENT SYSTEM
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENTS

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM
A049 SUPPLIER AWARENESS

Huerin

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

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Acier Duval Steel div. JD Welding Inc.
5888 County Road 17, Plantagenet ON. K0B1L0
Tel: 613-673-4574 ~~ toll free\ sans frais 1-866-831-5722
info@adsindustries.com www.adsindustries.com

Certificate of Conformance (CoC)

Customer Name	Dart Aerospace
P.O. Number	POHB044981
Part Number	D2521P (Job : 202741)
Drawing Number	D2521 Rev A
Material thickness	1"
Quantity	14
Invoice \ Packing slip #	8123

DAS
81
9-89

All technical requirements of the contract are satisfied. Quality and performance are in accordance with the contract, the specifications, and all references and associated contractual drawing and document

I, as a supplier to Dart Aerospace, acknowledge and certify the material covered under this document is produced in accordance with the following:

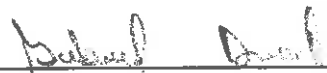
The Quantity in the P.O

The Drawing send to the administration

And other document send in regard to the pieces

*(Acknowledge by marking the boxes)

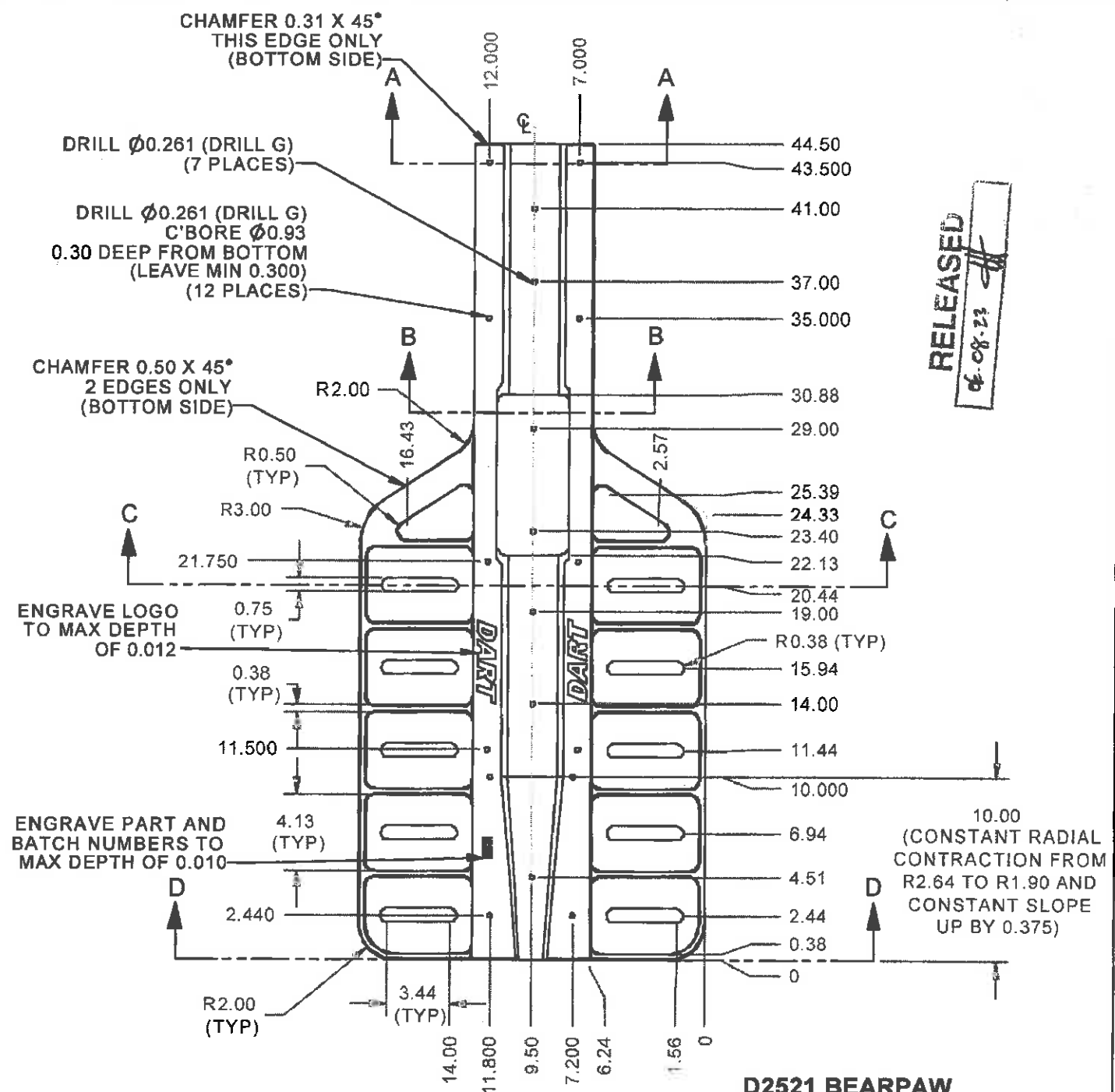
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	Quality Management	November 7 2019
Signature	Title	Date

This certifies the parts / items / material identified above conform to all applicable drawing and/or specification as evidenced by report or other documentation on file and all other purchase order and



DESIGN	DRAWN BY	DART AEROSPACE LTD	
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA	
DATE	DRAWING NO.	REV. J	SHEET 2 OF 3
06.07.28	D2521	SCALE	1:8
TITLE		205 BEARPAW	



NOTES:

- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.000 THICK (MACHINE TO 0.950)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.030
- 6) PART IS SYMMETRIC ABOUT C

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DART AEROSPACE LTD		Work Order:	202741
Description: Bearpaw		Part Number:	D2521
Inspection Dwg: D2521 Rev: J		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension			Actual Dimension	Accept	Reject	Method of Inspection	Comments
Dim	Min	Max					
A	0.260	0.266	0.260	✓		G.P.	
B	0.90	0.96	0.930	✓		Ver	CNC 20
C	0.27	0.330	0.315	✓		Ver	"
D	0.470	0.530	0.500	✓		Ver	"
E	21.740	21.760	21.750	✓		TAPE	
F	0.72	0.780	0.750	✓		Ver.	"
G	0.35	0.410	0.380	✓		Ver.	"
H	11.490	11.570	11.500	✓		Ver	CNC 02
I	3.41	3.47	3.44	✓		Ver	CNC 20
J	11.790	11.810	11.800	✓		Ver	CNC 20
K	9.47	9.53	9.500	✓		Ver	CNC 02
L	7.190	7.210	7.200	✓		Ver	CNC 20
M	6.910	6.970	6.94	✓		Ver	"
N	44.47	44.530	44.50	✓		TAPE	
O	6.590	6.650	6.620	✓		Ver	"
P	0.940	0.980	0.960	✓		Ver	"
Q	18.97	19.03	19.00	✓		TAPE	
R	0.350	0.410	0.380	✓		Ver	"
S	0.740	0.780	0.765	✓		Ver	"
T	0.240	0.280	0.265	✓		Ver	"
U	0.370	0.410	0.390	✓		Ver	"
V	0.740	0.780	0.760	✓		Ver	"
W	0.740	0.780	0.765	✓		Ver	"

Measured by: ^{DAS} 52	Audited by: 	Prototype Approval:	N/A
Date: ⁹⁻⁸⁹ 19/11/19	Date: 19/11/25	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D205-564-011 & D430-688-011	KJ/RF	
B	05.06.15	Dimensions and tolerances changed	KJ/RF	
C	06.08.31	Dimensions updated per D2521 Rev. J	KJ/JLM 	